

Date: Wednesday, 18/06/2008 1:27:18 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TOP PANNEL ASS'Y
Job Number :	39930		
Estimate Number :	13067		
P.O. Number :		Part Number :	D3650041
This Issue :	18/06/2008	Drawing Number :	D3650 REV.B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	B
Previous Run :	36912	Material :	
Written By :		Due Date :	07/07/2008
Checked & Approved By :	JUL 08.6.18	Qty:	3 Um: Each
Comment :	Est Rev:A New Issue 07-11-12 EC verified by: DD Est Rev:B Ecn 1113P 08-01-22 DD verified by: EC Est Rev:C Ecn1162 08-04-02 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 pick kit

2.0	D36501	Aft Panel
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 AFT PANEL
 batch B 36941 / 39932

3
 FF 08-07-30

3.0	D36503	Center Panel
-----	--------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 CENTER PANEL
 batch 39933

3
 FF 08-07-30

4.0	D36505	Fwd Panel
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 CENTER PANEL
 batch B 39934

3
 FF 08-07-30

5.0	AN3C3A	Bolt
-----	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Bolt
 batch 108473

3
 08-07-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:27:18 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANNEL ASS'Y

Job Number: 39930

Part Number: D3650041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 8.0000 EACH(s)/Unit Total: 16.0000 EACH(s)

WASHER

batch

M108473

18 08/07/30 3

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3650

2- Seal all mating surfaces and all gaps using Proseal 700 fire wall sealant
as per dwg D3650

Batch: M108789

FF 08-08-05

3

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/05 3

1

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

39920

FF 08-08-06

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

18/08/08

Job Completion



18 08-08-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

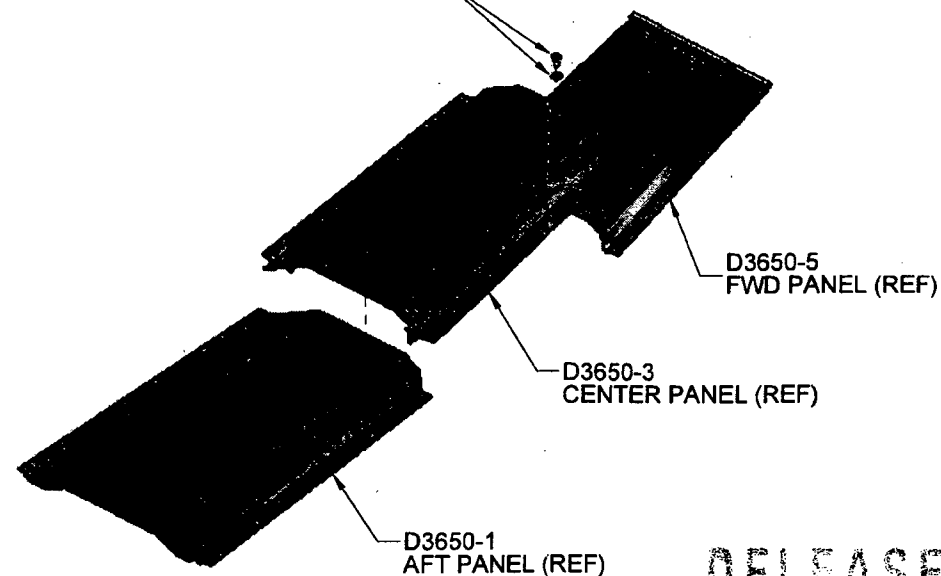
4

3

2

1

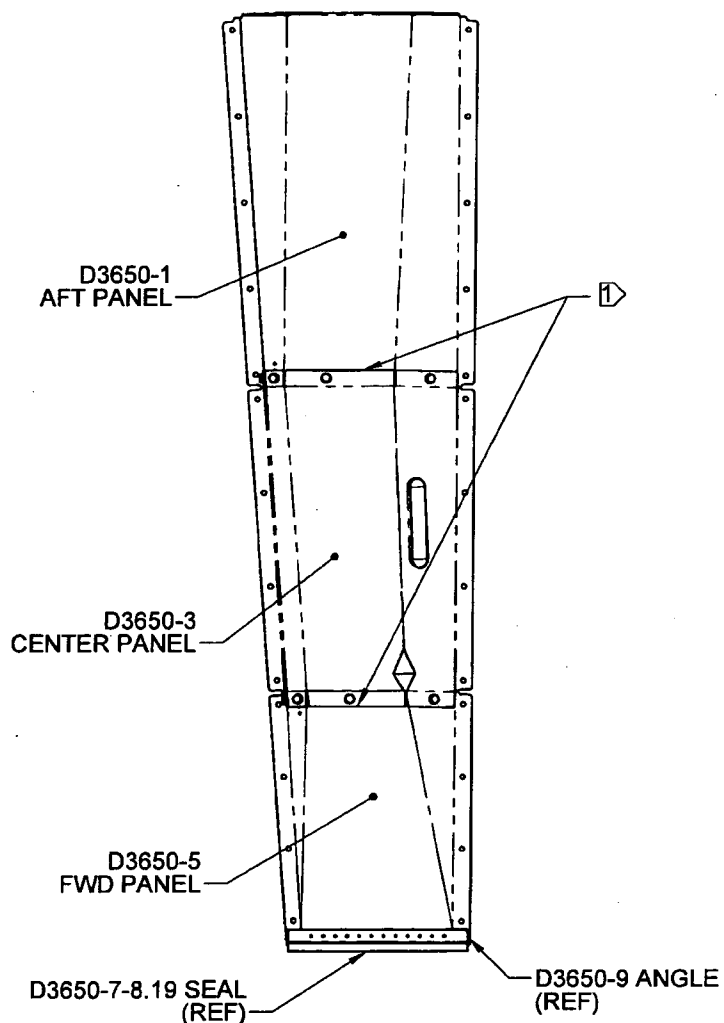
AN3C-3A BOLT (1)
AN960C10 WASHER (1)
(8 PLACES)



RELEASED
08-23-17/W

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



D3650-041 TUNNEL TOP PANEL ASSEMBLY

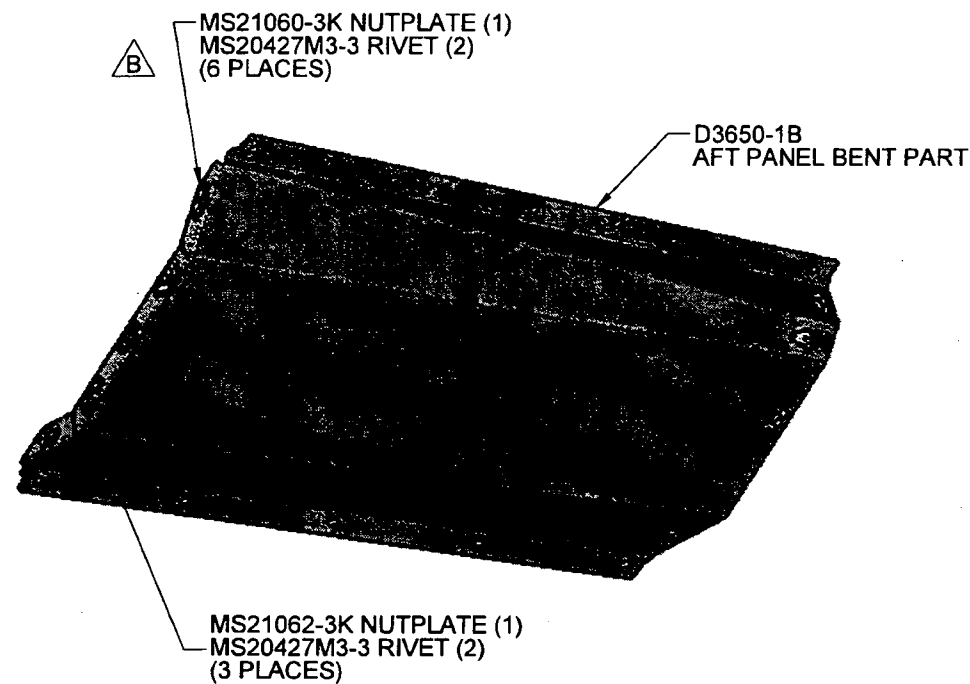
NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

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B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL I SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F		RF	08.01.07
A	NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	LE	DRAWING NO. D3650		REV. B
MFG. APPR.	DA			SHEET 1 OF 9
APPROVED	DA	TITLE TOP PANEL ASSEMBLY		SCALE 1:8
DE APPR.	#			
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8 7 6 5 4 3 2 1

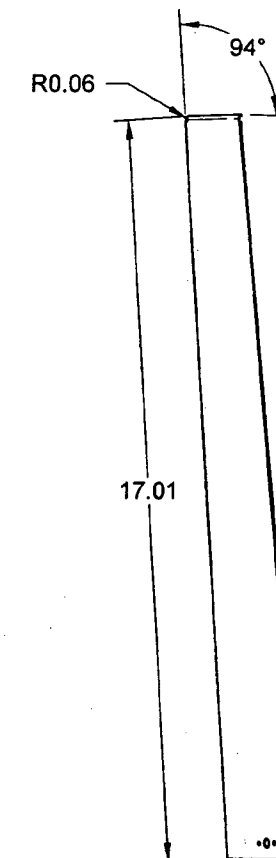
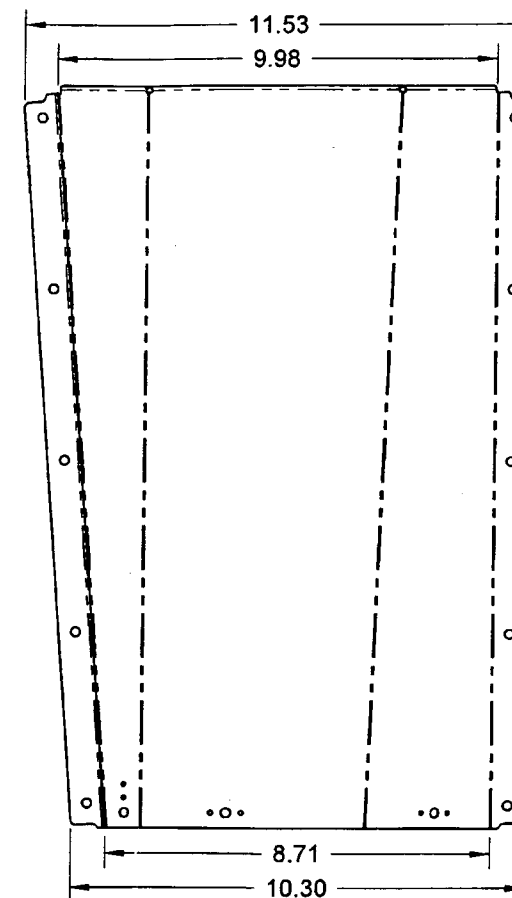
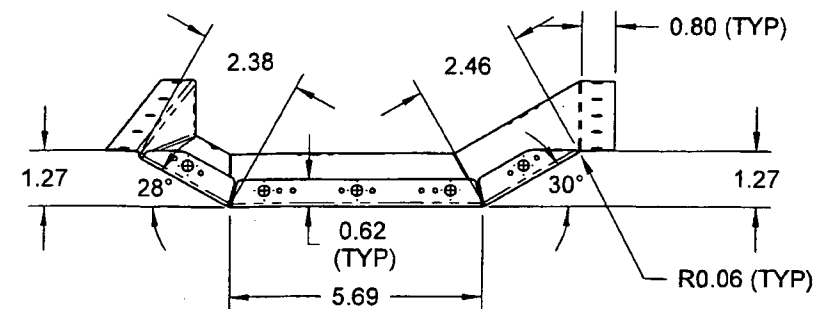


D3650-1 AFT PANEL

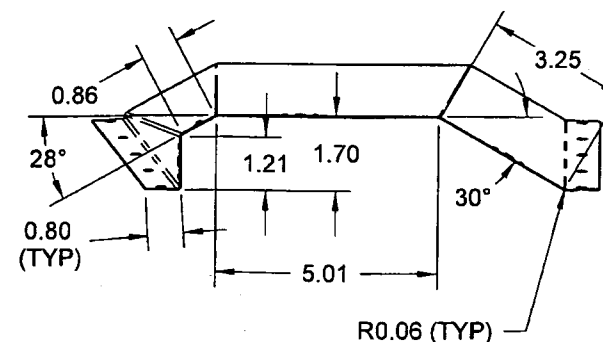
PART LIST

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

- NOTES:**
1) FINISH: NONE
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
5) IDENTIFICATION: NONE
6) WEIGHT: 1.3 lbs



D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

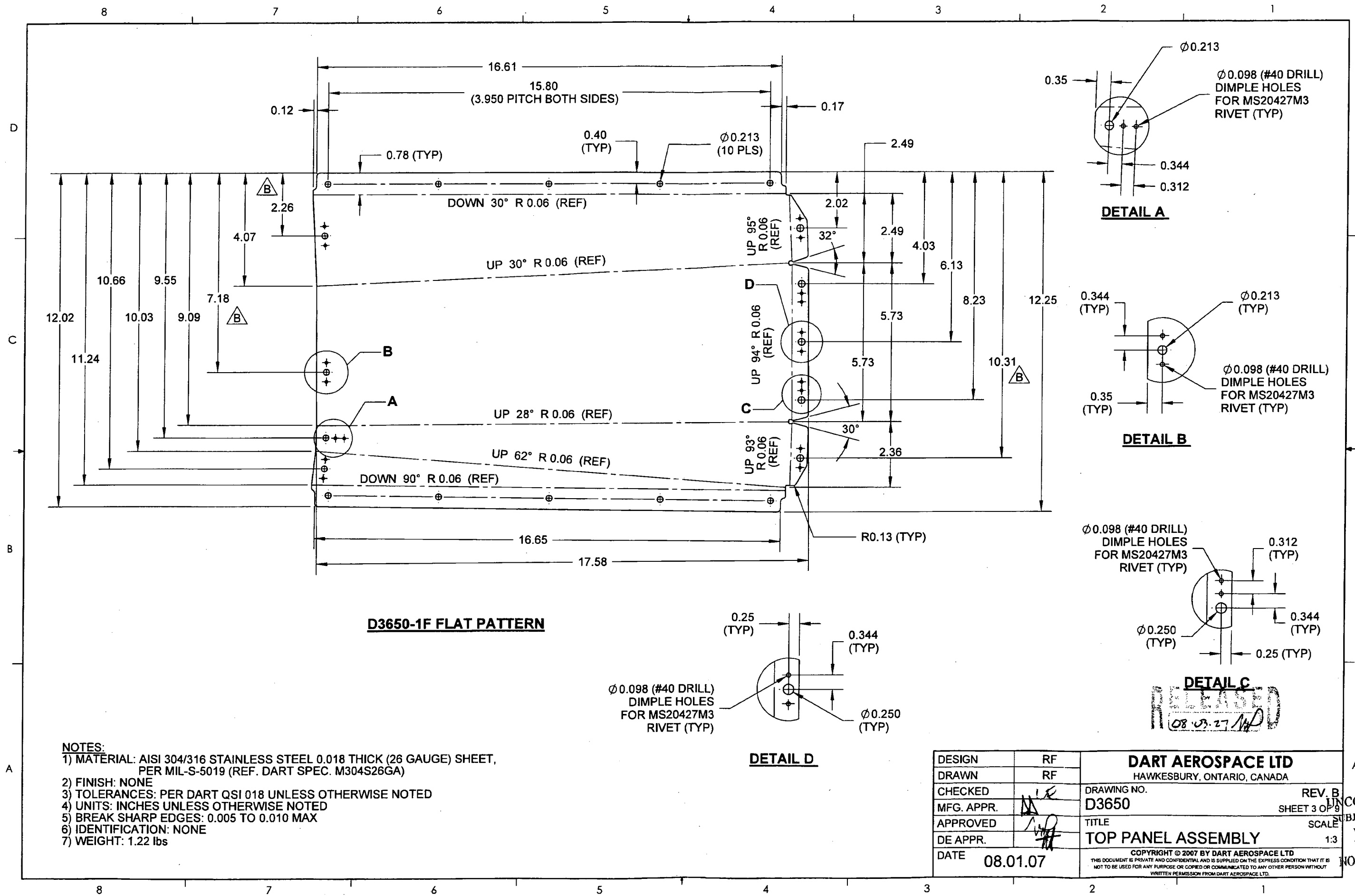


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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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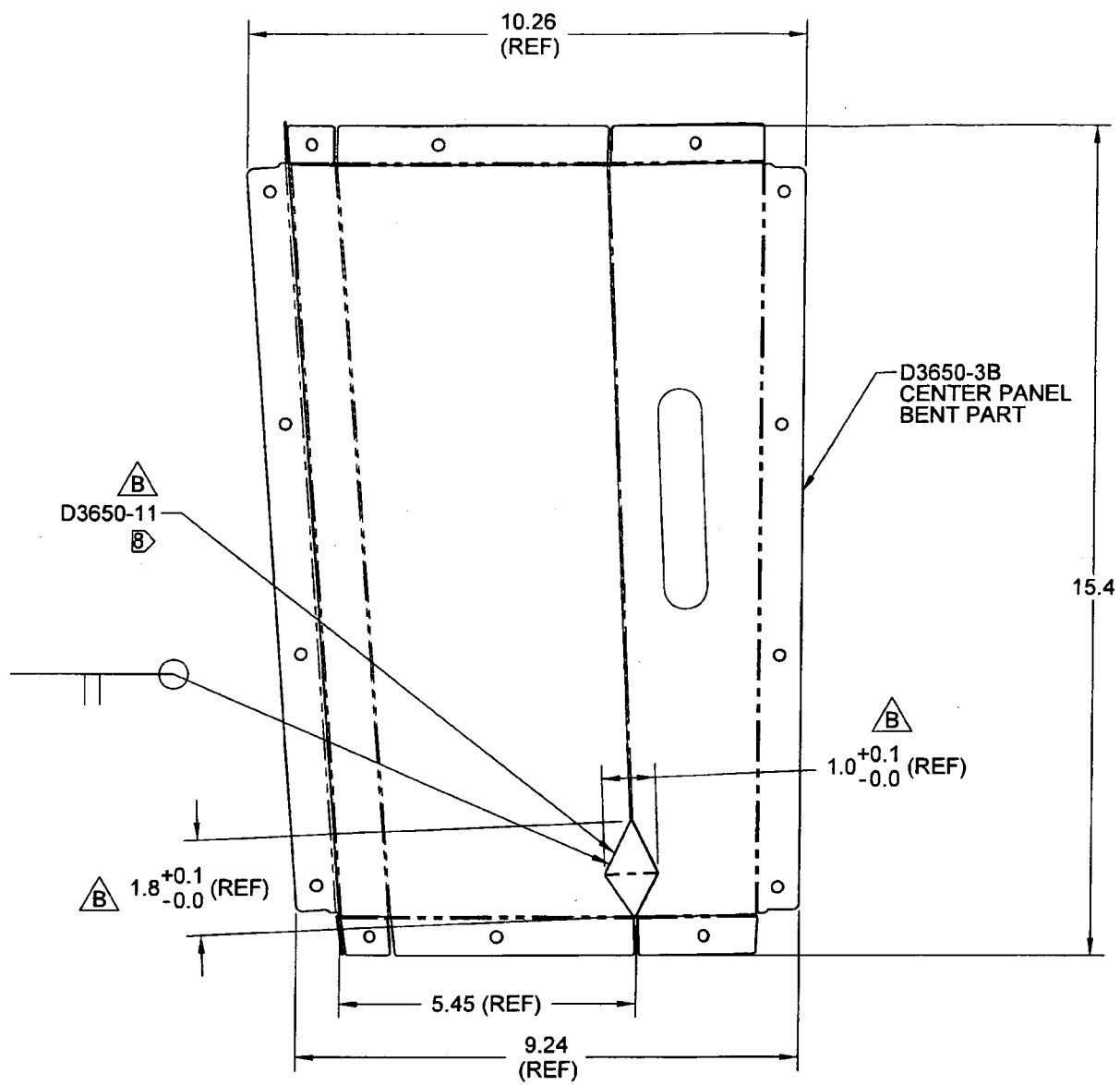
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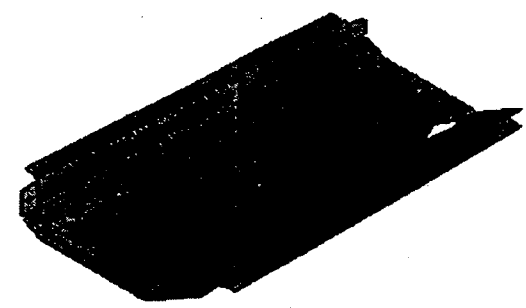
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.22 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
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D3650-3 CENTER PANEL



PART LIST

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

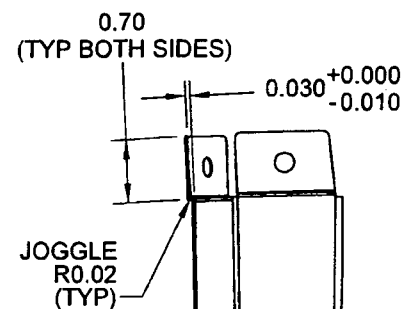
NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

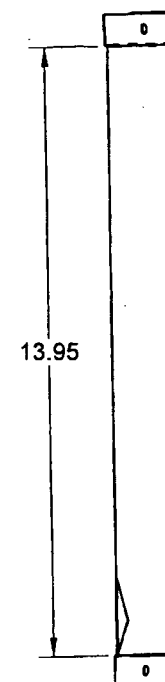
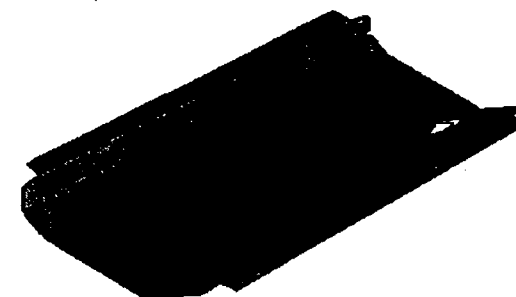
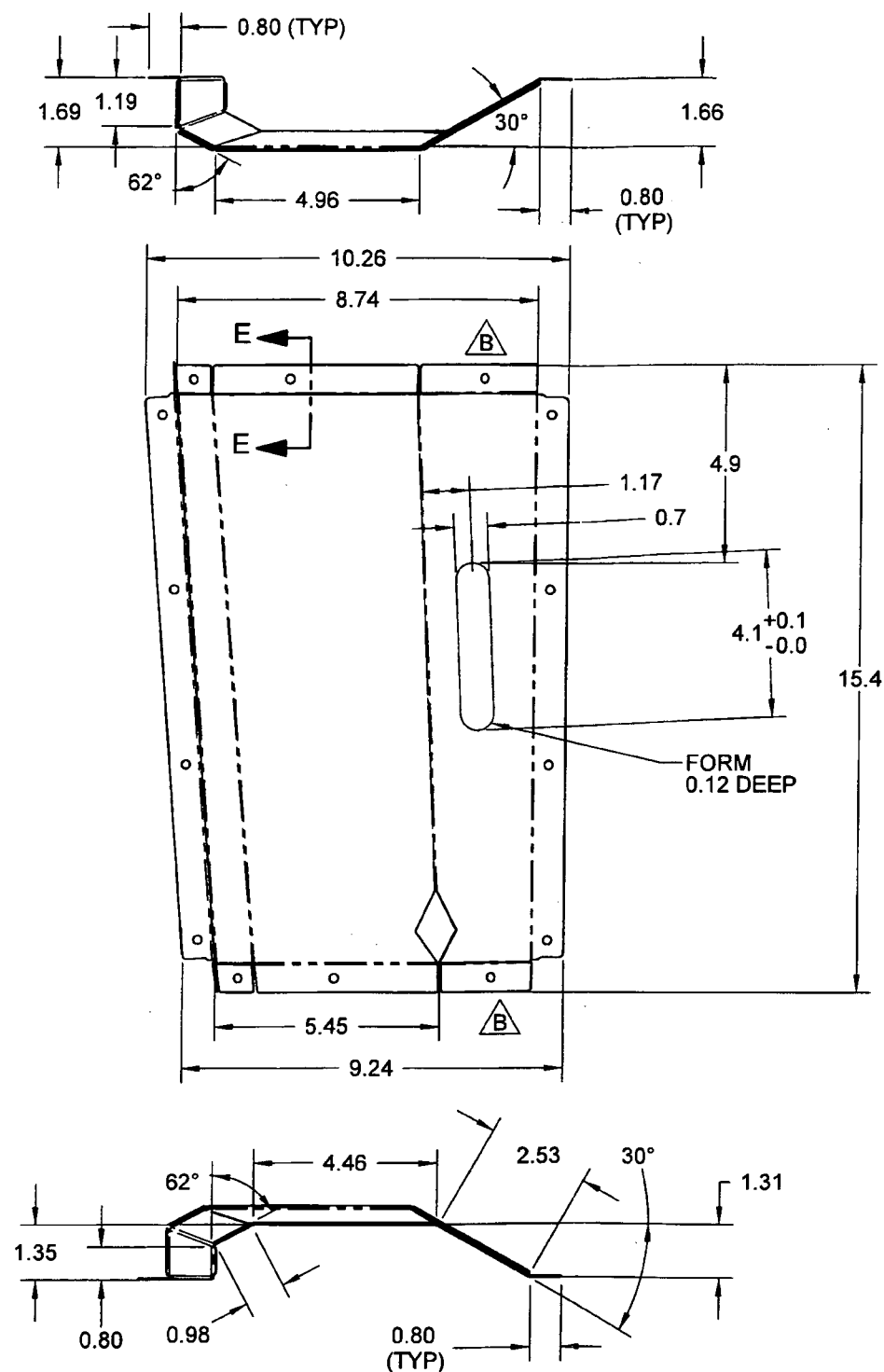
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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	LE	DRAWING NO. D3650
MFG. APPR.		REV. B SHEET 4 OF 9
APPROVED		TITLE TOP PANEL ASSEMBLY
DE APPR.		SCALE 1:3
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




SECTION E-E



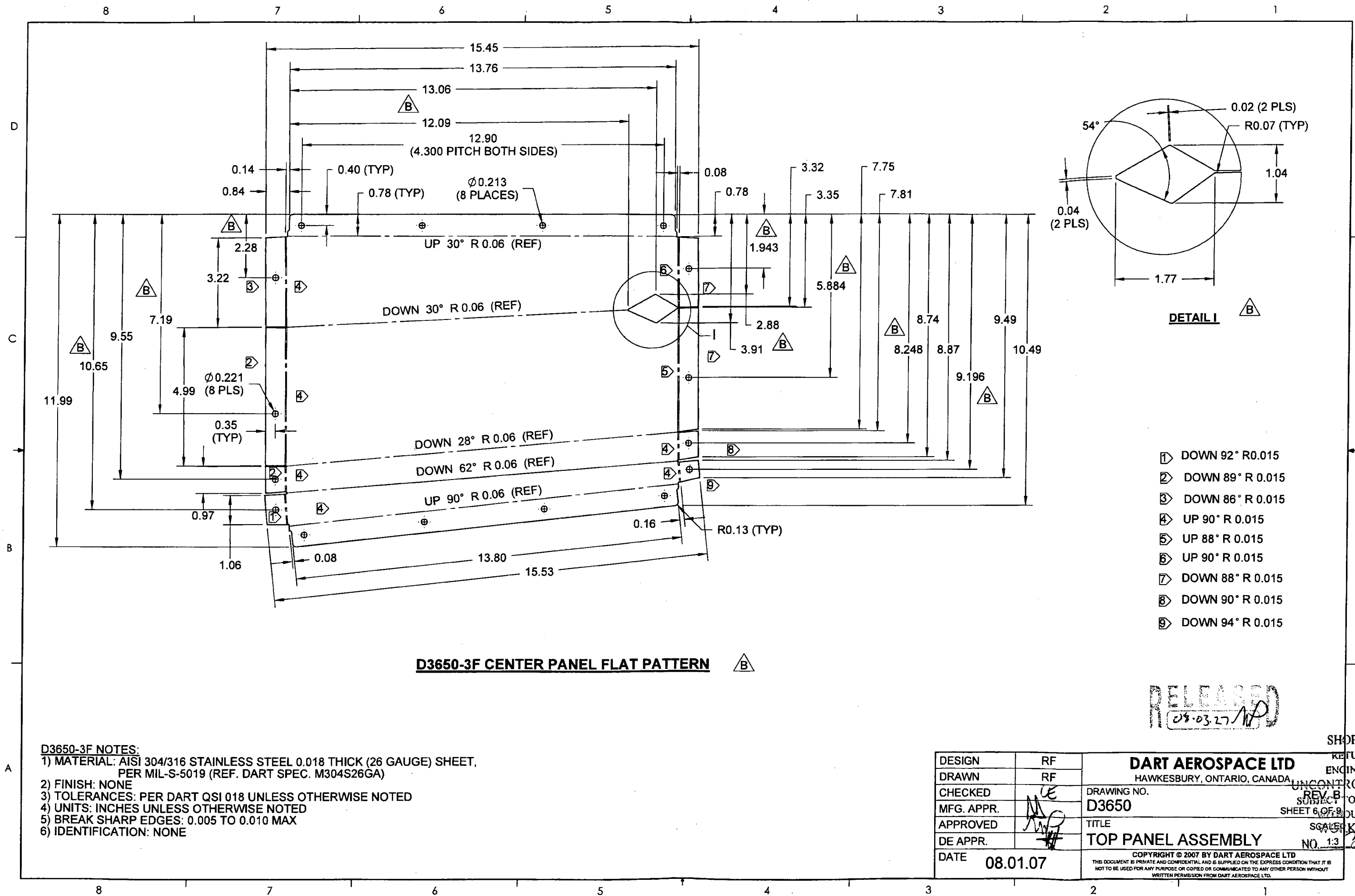
- NOTES:**
- 1) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

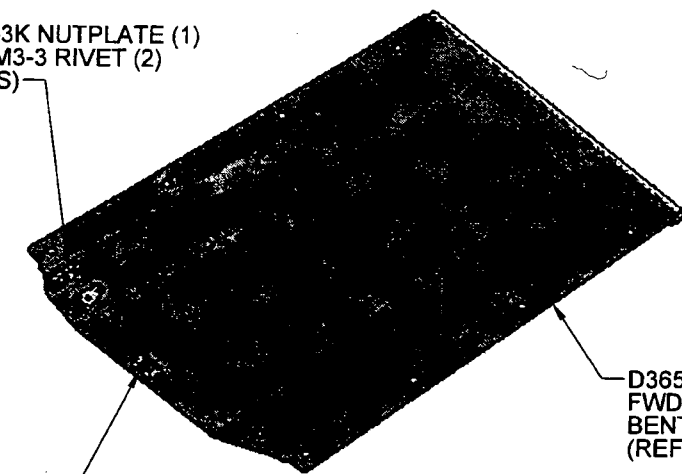
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)



D3650-5B
FWD PANEL
BENT PART
(REF)

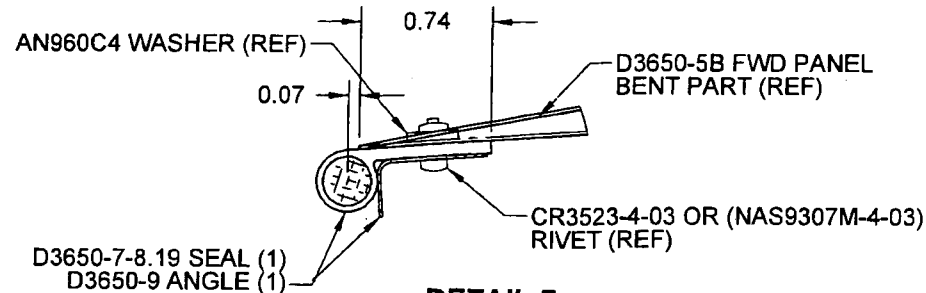
MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

PART LIST

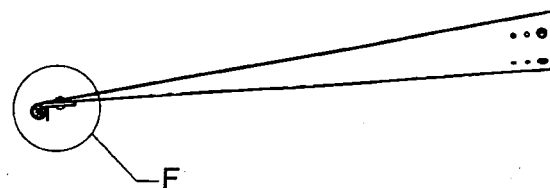
QTY -5	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

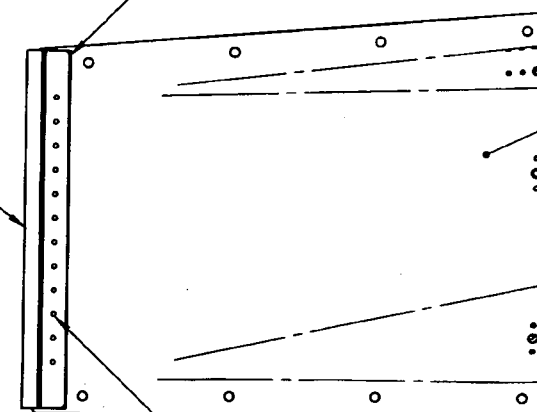


DETAIL F



D3650-9 (REF)

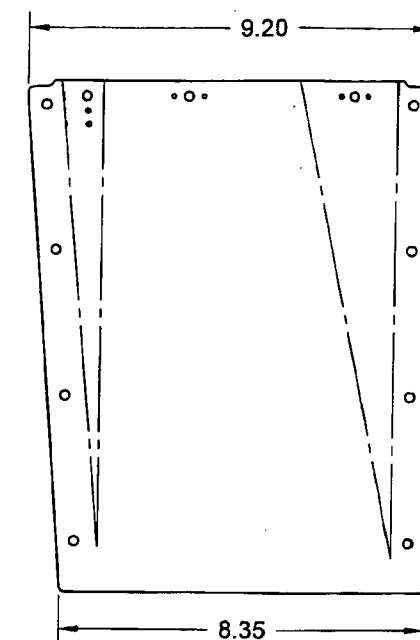
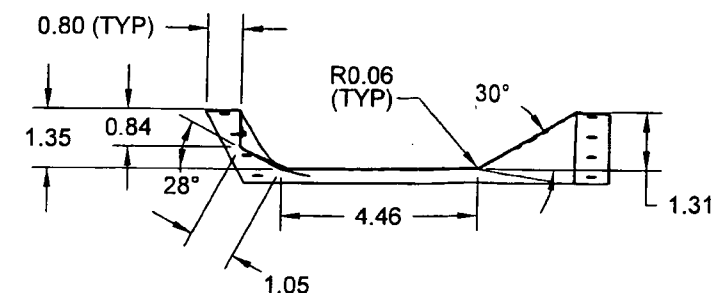
D3650-7-8.19
(REF)



D3650-5B
FWD PANEL
BENT PART

CENTRE D3650-7/-9 ON D3650-5B &
TRANSFER $\varnothing 0.129$ (#30 DRILL) HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)

D3650-5 FWD PANEL

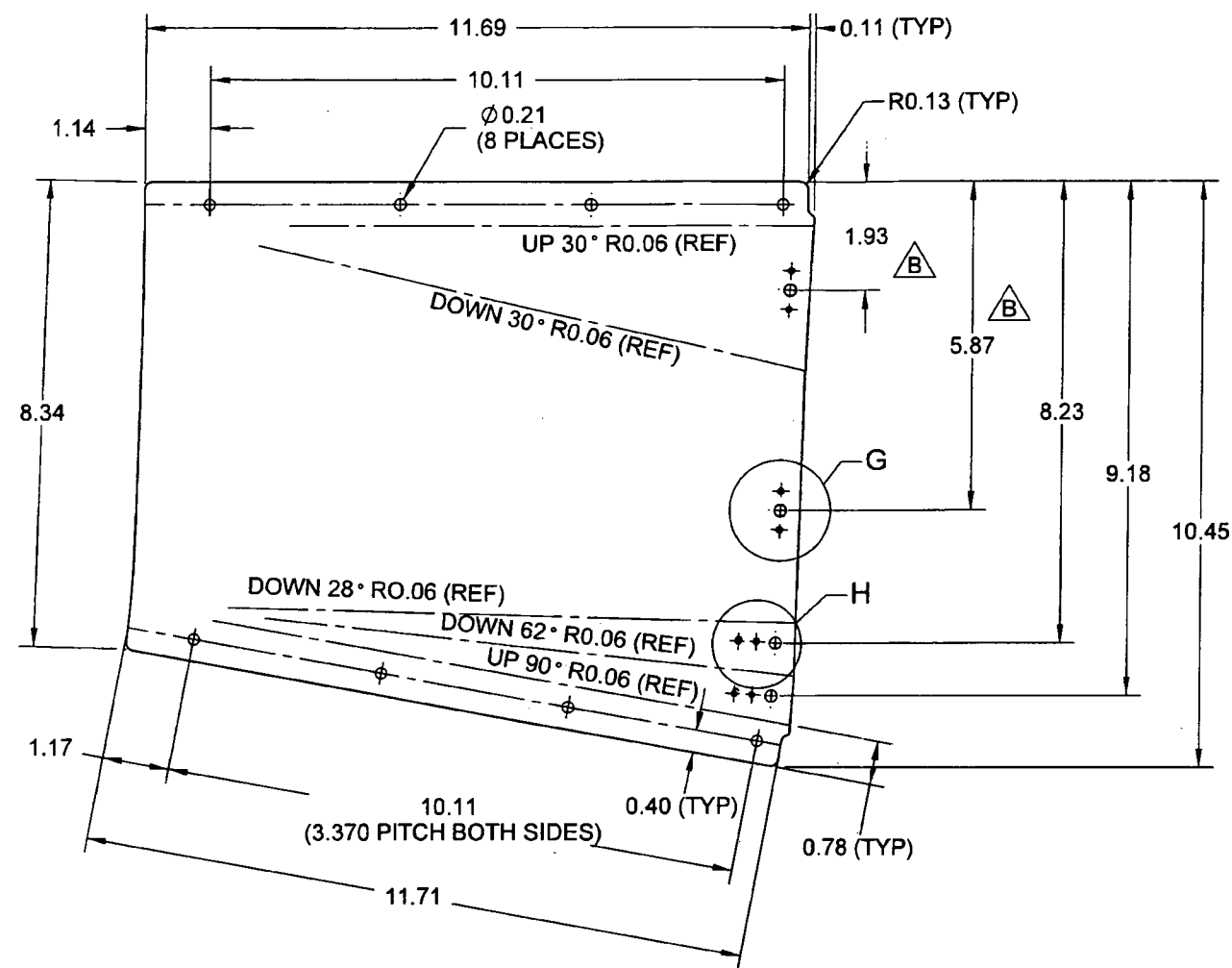


D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

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03/03/27/WP

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VE	DRAWING NO.	REV.
MFG. APPR.	MA	D3650	SHEET 7 OF
APPROVED	MC	TITLE	SCALE
DE APPR.	MC	TOP PANEL ASSEMBLY	1:
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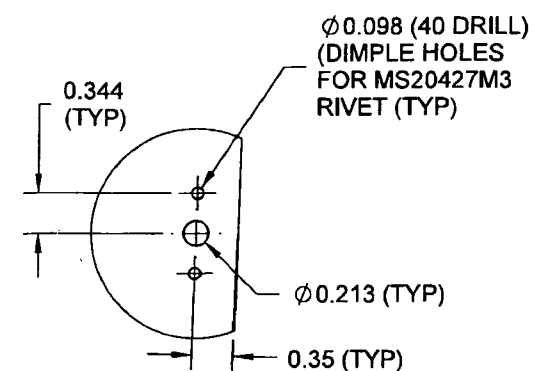
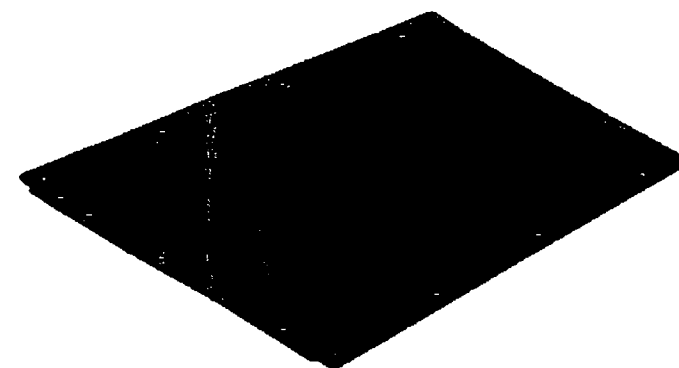
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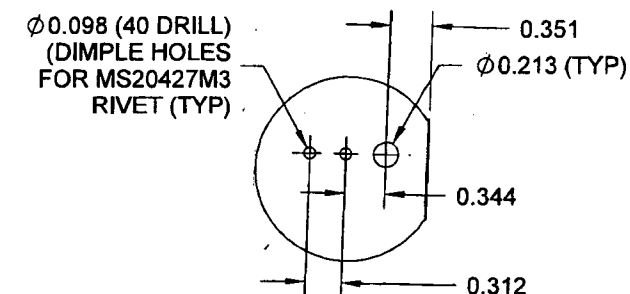
D3650-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb



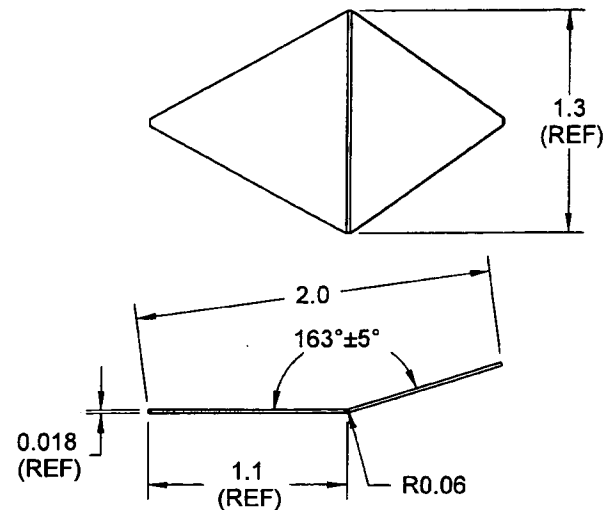
DETAIL G
(2 PLS)



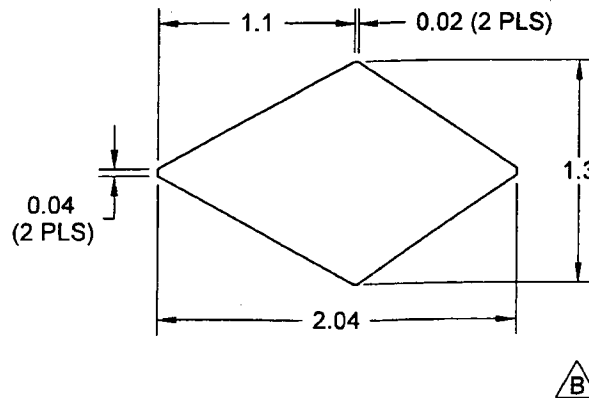
DETAIL H
(2 PLS)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 8 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	UNCONTROLLED COPY
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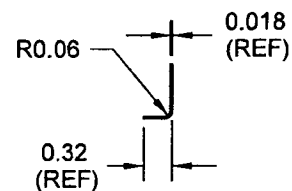
WORK ORDER
NO. 39920



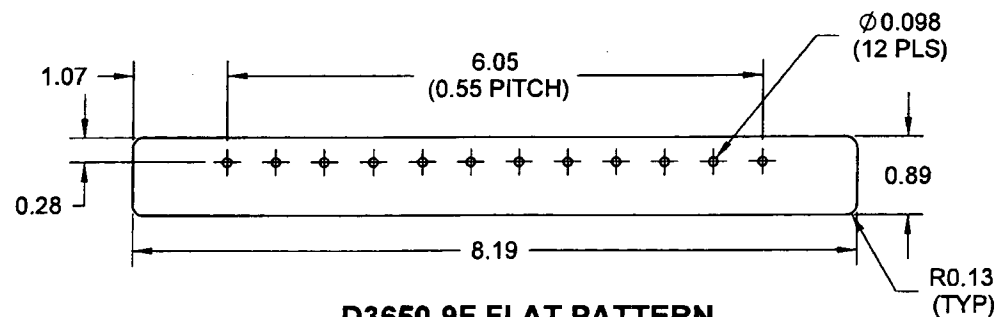
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



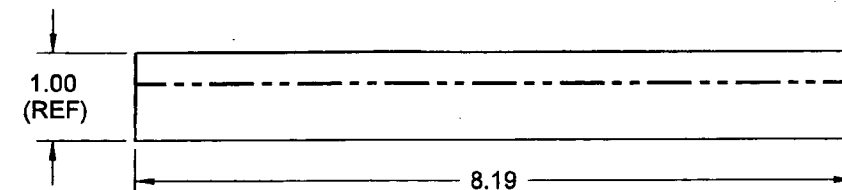
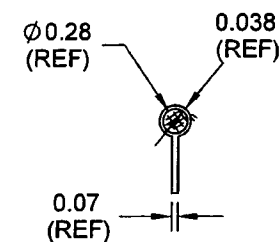
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-9F FLAT PATTERN



D3650-7-8.19 SEAL

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 9 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	UNCONTROLLED COPY
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